

Blue  
**Work Order ID 62618**

October 5, 2010 11:45:28 AM

Page 1

Item ID: D206-642-441

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00

Required Date: 10/22/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *H*

Date: *10-10-08*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

*N/A*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62618

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Item ID: D206-642-441

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M112507 / M115778								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end 138.60" from front of tube								
	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".								
	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".								
	8-Open using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

> DP

10-10-6

>

DP

10-10-7

W/O:		WORK ORDER CHANGES					
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**Work Order ID 62618**

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Item ID: D206-642-441

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Setup Start

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Stop

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*[Handwritten signature]* *BE 10/10/07*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 62618**

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Stop



Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-10-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 62618**

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Item ID: D206-642-441

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Start Date: 10/05/10 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.  
cure time before cutting☐Start Date: 345 PM  
Time: 10-10-7☐Finish Date: 10/10/12  
Time: 8:30 AMA/R ☐ Sikaflex-291 ☐ M115114 ☐

Sikaflex expiry date: 11-1-30

DP 10-10-7

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

160

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod M111385

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.50" deep as per Dwg D2650 Deburr

FD

1

PE 10/10/20

FD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval' QC Inspector

Part No: D206-642-441 PAR #: \_\_\_\_\_ Fault Category: Skid plates NCR: Yes No DQA: [Signature] Date: 10/10/20  
 Resolution: rework Disposition: rework QA: N/C Closed: [Signature] Date: 10/10/28

NCR: <u>62618</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/20	160-3	Pilot broke inside of the 13th x-bolt (towards the Aft) aka fwd yhw location, going through the x-bolt. When the bit was changed, 6 more x-bolt spacers were bored too deep. This was caused by the bit being 0.080" longer than normal & stopper needed to be adjusted. R.C: Tooling / New brand of bits	<u>[Signature]</u>	<del>Remove</del> From Fuel → Aft, remove the affected x-bolt spacers: 7 → 13. ∴ re-weld new ones in place. A/R M11385 D2629 B62889	<u>[Signature]</u> 10-10-20 BE 10-10-20	<u>[Signature]</u> 10/10/20	<u>[Signature]</u>	<u>[Signature]</u> 10-10-20
			<u>[Signature]</u>		BE 10-10-20	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

**Work Order ID 62618**

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Item ID: D206-642-441

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00



HandFinishing

Skidtubes

Memo

0.00

Skidtubes

Install D2680-041 Nut Plate as per Dwg D2650

1 - 360/10/20

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

1 - 10/10/20

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

1 - 10/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 62618

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Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

=> M 10/10/21 1 0

211

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 114424  
PAINT DELFLEET BLUE B 115609  
CLEAR DELFLEET B 113314

RT 10-10-23 (C)

221

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

ml 10 10 85 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 62618

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Item ID: D206-642-441

Accept



Setup Start



Revision ID:

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Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

0.00



HandFinish

Hand Finishing

HandFinishing

Memo

0.00

=> JH

10/10/10 24

1

0

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ M114693

Sikaflex expiry date: ☐ 10/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☒ M114057

Sikaflex expiry date: ☐ 10/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: A115790

[Signature]

[Signature]

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/10/26

0.00

Memo



250



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-642-441

Location:

PPP Rev: PPP 62623

6/10/28 (2)

260



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/28

MK

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 62618

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube




Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC  
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K  
 10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	1,214.000	60	60			
<div>  </div> <div>           Insert         </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				PKG11		1165		1115911		Y60			
					114723	1165							
				ST282		10							
					110511	10							
				ST381		39							
					114654	39							
AN960JD10L	NAS1149D0332J	Purchased	No			230	Each	0.0000	2	2			
<div>  </div> <div>           Washer         </div>													
						1114348				Y241		10/10/24	
AN960JD416	NAS1149D0463J	Purchased	No			230	Each	24.0000	1	1			
<div>  </div> <div>           Washer         </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		24		1115622		Y1			
					113288								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

170

Each

446.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

446

112314

4

113539

44

113973

398

CR3212-4-03

Purchased

No

230

Each

1,888.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1888

111359

5

112314

2

114436

448

114450

71

114859

1362

D2620

Manufactured

No

110

Each

8.0000

1

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

8

61632

8

2 BE 10/10/20

2 BE 10/10/20

10-10-6

October 5, 2010 11:45:17 AM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October 5, 2010 11:45:17 AM

Page 3

Work Order ID: 62618

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

110

Each

50.0000

1

1



Aft Cap

*blue*

*X*



*10/10/12*

Location

Loc Qty

Loc Code

FP-4

45

57332

45

fp5

1

61752

1

FP6

4

52663

4

*62652*

*y1*

D2647

Manufactured No

140

Each

66.0000

1

1



Cap



Location

Loc Qty

Loc Code

FP

66

55352

66

*1*

*BE 10/10/06*

D2649

Manufactured No

170

Each

65.0000

23

23



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

65

58545

2

60652

4

61496

59

*B 62889*

*30*

*BE 10/10/20*

October 5, 2010 11:45:17 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

October 5, 2010 11:45:18 AM

Work Order ID: 62618

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

230

Each

622.0000

22

22



Plug

blue



10/10/24

Location

Loc Qty

Loc Code

FP

252

51530

152

61751

100

fpa

370

53349

235

57869

135

y14

y8

D2651-3

Manufactured No

230

Each

626.0000

22

22



O-Ring



10/10/24

Location

Loc Qty

Loc Code

FP

626

46114

130

61962

496

y22

D2654-7

Manufactured No

160

Each

0.0000

1

1



Web



DD 10-10-7

D2680-041

Manufactured No

170

Each

29.0000

1

1



Nut Plate



B62685

Location

Loc Qty

Loc Code

ST021

29

55366

29

BE 10/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

October 5, 2010 11:45:18 AM

Work Order ID: 62618

Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10



Start Qty: 1.00

Required Qty: 1.00

D3535-15	Manufactured	No	230	Each	6.0000	1	1
							yl 10/10/24
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP18	6	
61241	6	yl

D3535-23	Manufactured	No	230	Each	19.0000	1	1
							yl 10/10/24
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	7	
61830	7	
FP021	20	
60231	11	yl

D3535-37	Manufactured	No	230	Each	9.0000	1	1
							yl 10/10/24
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	9	
56101	9	yl

D3536-15	Manufactured	No	230	Each	10.0000	1	1
							yl 10/10/24
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	9	
56055	1	
60875	8	yl
FP11	1	
59238	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

October 5, 2010 11:45:19 AM

Work Order ID: 62618

Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10



Start Qty: 1.00

Required Qty: 1.00

D3536-23	Manufactured	No	230	Each	8.0000	1	1
							<u>yl 10/10/24</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP011	8	
<u>61237</u>	8	<u>yl</u>

D3536-37	Manufactured	No	230	Each	8.0000	1	1
							<u>yl 10/10/24</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	8	
<u>56102</u>	8	<u>yl</u>

D3537-1	Manufactured	No	230	Each	14.0000	6	6
							<u>yl 10/10/24</u>
Wearpad							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	1	
55465	1	
FP17	13	B61986
57713	3	<u>yl</u>
60491	3	
61640	7	

D3537-3	Manufactured	No	230	Each	8.0000	1	1
							<u>yl 10/10/24</u>
Wearpad							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP17	8	
<u>60866</u>	8	<u>yl</u>

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries



# Picklist Print

October 5, 2010 11:45:19 AM

Page 7

Work Order ID: 62618

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

230

Each

1,585.000

2

2



10/10/24

Screw

Location

Loc Qty

Loc Code

ST291

1585

110835

473

114718

112

115108

1000

Y2

MS27039-4-06

Purchased

No

230

Each

108.0000

1

1



10/10/24

Screw

Location

Loc Qty

Loc Code

ST292

108

109064

14

115460

94

Y1

MS27039C1-08

Purchased

No

230

Each

1,077.000

60

60



10/10/24

SCREW

Location

Loc Qty

Loc Code

FP

276

115336

276

ST293

801

115589

800

19185

1

Y60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October 5, 2010 11:45:20 AM

Page 8

Work Order ID: 62618



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,239.000

60

60



10/10/24

Washer

Location

Loc Qty

Loc Code

ST297

5239

113524

10

113737

150

115000

125

115698

78

115816

1276

115832

3600

V60

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SUP  
R  
F  
UNCO  
SUB  
W  
W  
NO. 02418  
01/10-10-05

RELEASED  
08-07-23/17

# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

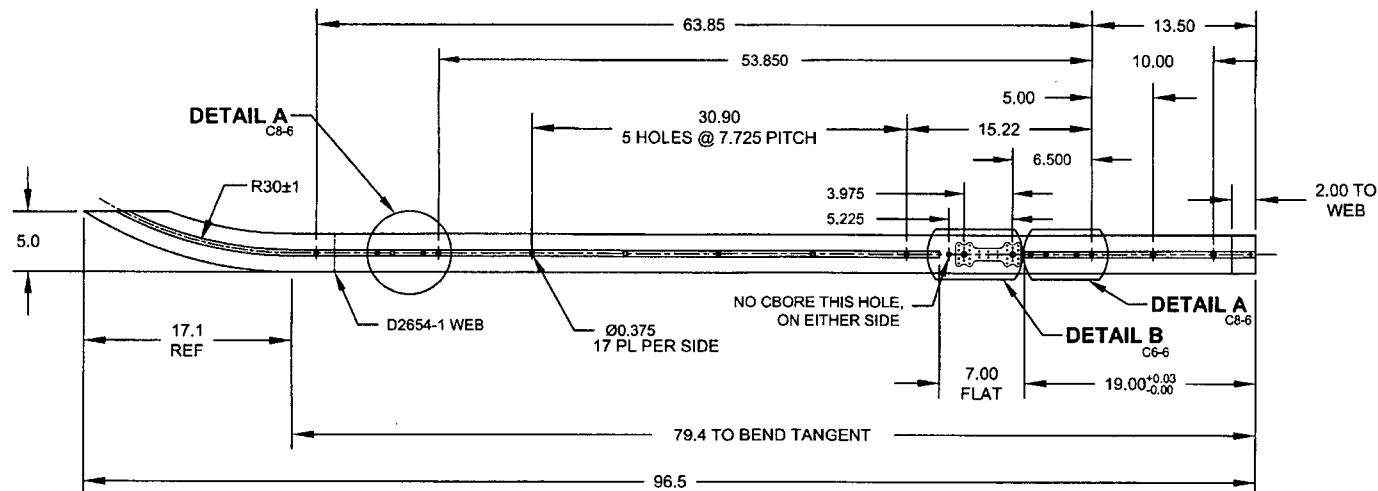
**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

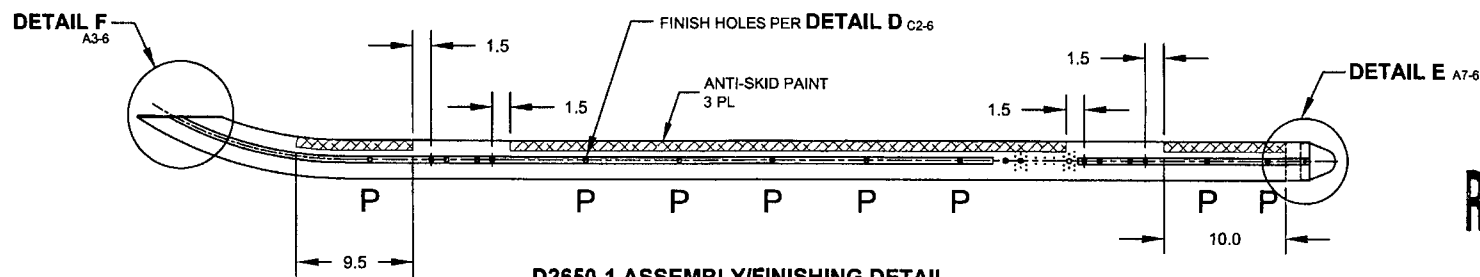
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





**NOTE:** Date & initial all entries



**D2650-1 BENDING/DRILLING DETAIL**



**D2650-1 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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RELEASED  
68092214P

*wlo 6/26/8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

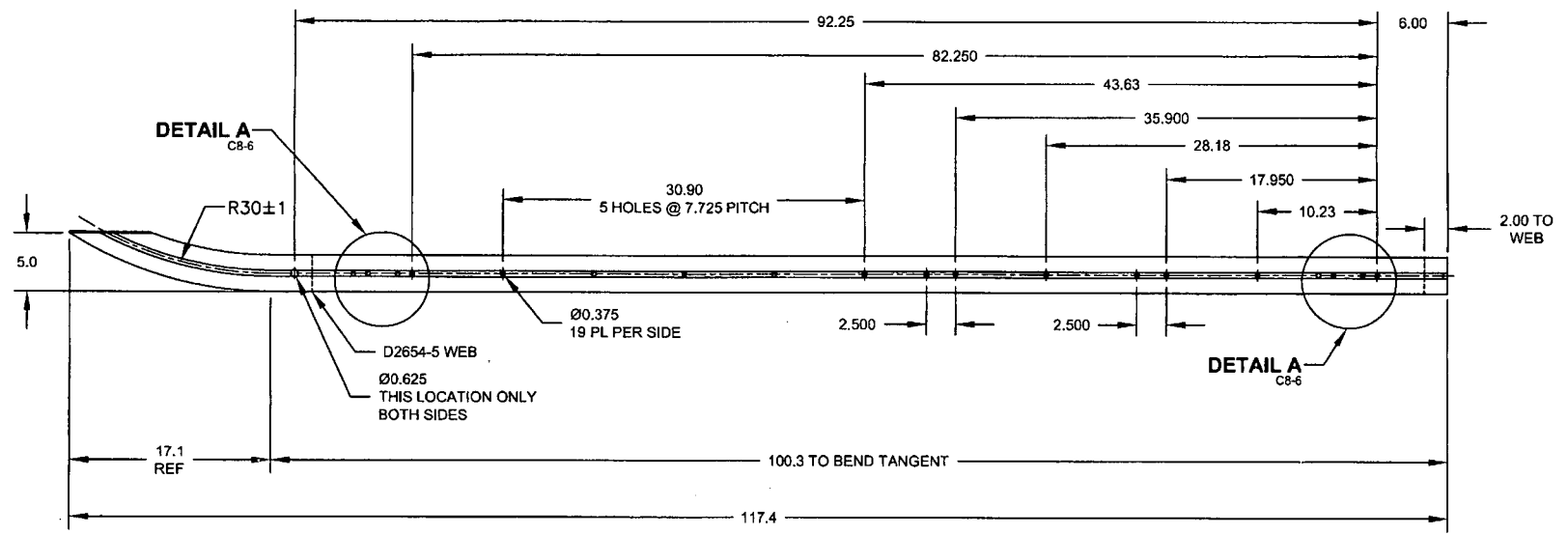
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

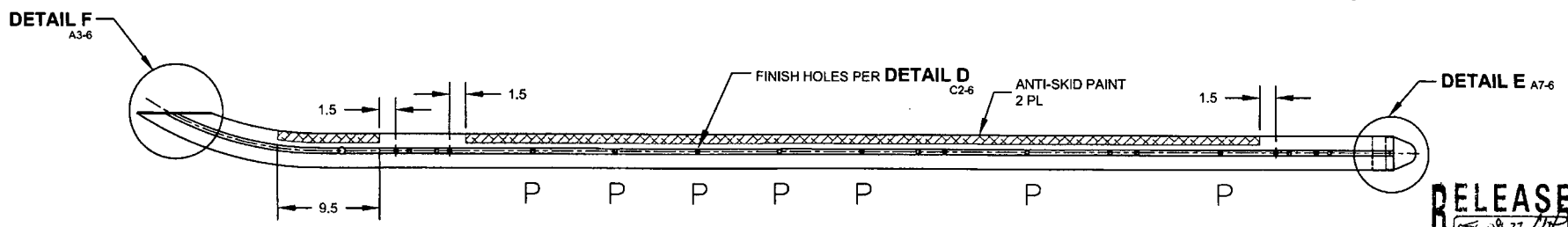
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D2650-5 BENDING/DRILLING DETAIL**



**D2650-5 ASSEMBLY/FINISHING DETAIL**

*w/o 62418*

**RELEASED**  
09-22-17

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	E	D2650	SHEET 4 OF 6
APPROVED	JP	TITLE	SCALE
DE APPR.	H	206/407 SKIDTUBE ASSEMBLIES	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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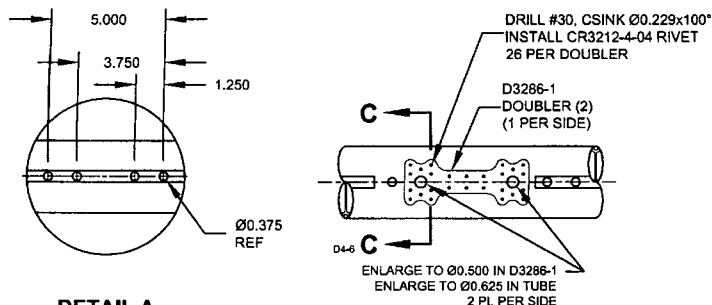
W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

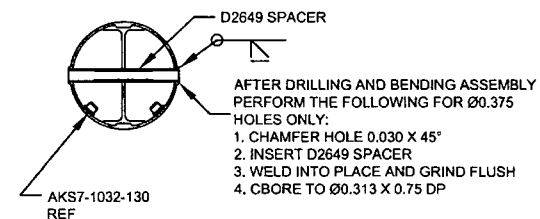
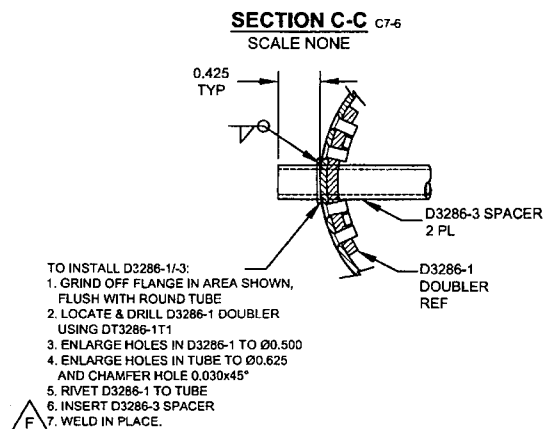
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



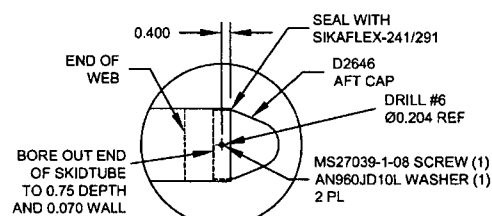
**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

**DETAIL B**  
SCALE 2X  
C3-2  
C3-3

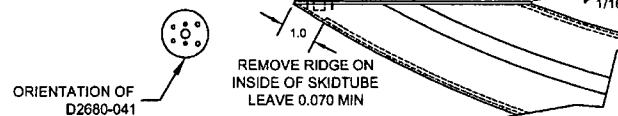


**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5

*w/o 62618*



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

**DETAIL F NOTES:**  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS NECESSARY)  
4. WELD D2647 IN PLACE PER DART QSI 004  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR  
TO FINISH

**RELEASED**  
05-09-22-198

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries